

Work Order ID 109514

109514

Page 1

November-25-13 7:16:26 AM

Item ID: D4839-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Blade
Start Date: 11/21/13 Start Qty: 16.00 *16* Cust Item ID:
Required Date: 11/21/13 Req'd Qty: 16.00 *16* Customer:
Reference: Rework

Approvals: Process Plan: MLJ Date: 11-11-25 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4839	REV A

100

0.00

100

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:
646.9711 B 102756

RE-IDENTIFY AS D4839-1

16

DAS
05
13-12-06

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

16

DAS
05
13-12-06

120

Identify as per dwg & Stock Location (composites) 0.00

120

Packaging

Memo

0.00

Packaging

Finishing

16

DAS
05
13-12-06

Work Order ID 109514

109514

Page 2

November-25-13 7:16:27 AM

Item ID: D4839-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blade

Start Date: 11/21/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/12/13
AB-12-4

Picklist Print

November-25-13 7:16:31 AM

Page 1

Work Order ID: 109514

109514

Parent Item: D4839-1

D4839-1

Parent Item Name: Blade

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 16.00

Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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646.9711

Manufactured

No

Each

215.0000

16

11/21/13 12:06

646 9711

Blade

Location

Loc Qty

Loc Code

CA

214

100268

97

102756

56

98911

61

ST437

1

91807

1

8 7 6 5 4 3 2 1

D

C

B

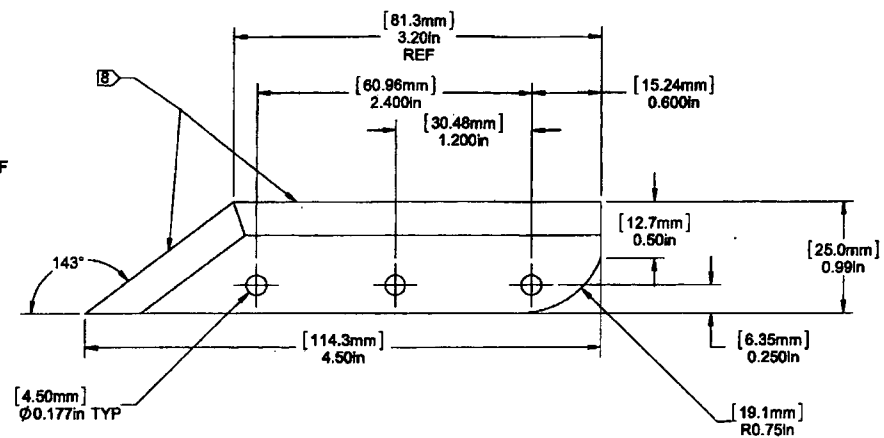
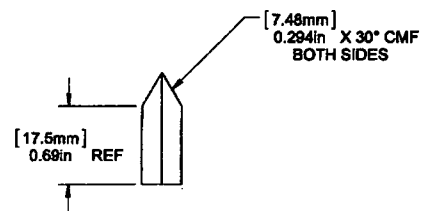
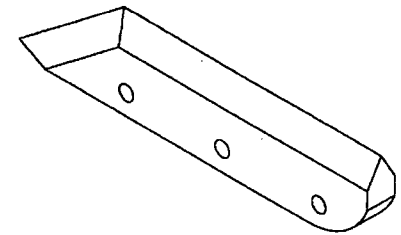
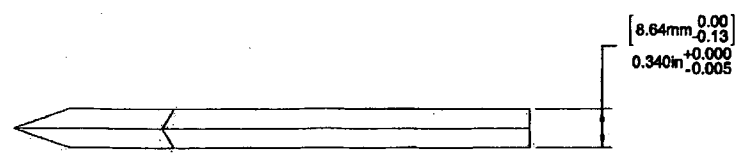
A

D

C

B

A



D4839-1 BLADE

109514 MJS
13-11-25

RELEASED
2013-07-12

NOTES:

- 1) MATERIAL: AISI A2 TOOL STEEL PER ASTM A681 (DART SPEC MSTEEL-A2-B0.375X4.500)
CONDITION: ANNEALED (HEAT TREAT TO 58-62 ROCKWELL C HARDNESS) PER MIL-T-8738 OR AMS2759/1E
- 2) FINISH: PRIME 1AW MIL-P-23377J TYPE1, CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs (0.13 kgs)
- 8) DO NOT BREAK EDGE OF BLADE, INTENDED TO BE SHARP
- 9) REFERENCE APICAL PART NUMBER 646.9711

A		NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	DB				
CHECKED	A.P.	DRAWING NO. D4839			REV. A
MFG. APPR.	AP				SHEET 1 OF 1
APPROVED	AP	TITLE			SCALE
DE APPR.	AP	BLADE			NTS
DATE	13.05.23				
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8 7 6 5 4 3 2 1

November-21-13 2:33:41 PM

Item ID: D4839-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blade

Start Date: 11/21/13 **Start Qty:** 16.00

16

Cust Item ID:**Required Date:** 11/21/13 **Req'd Qty:** 16.00

16

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4839	REV A

100

0.00

100

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

8 X 646.9711 B

RE-IDENTIFY AS D4839-1

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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